

Work Order ID 82995

82995

Page 1

Thursday, April 12, 2012 10:25:57 AM

Item ID: D3890-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Panel, Side

Start Date: 4/12/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/26/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MF

Date: 12-04-12 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3890

A

100

0.00

100

Waterjet

FLOW CNC Waterjet

ML EXS-0125

FG0029-04

Lexan

Memo

1-Cut as per Dwg D3890-1

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

4 0

Jm / 12-4-30

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control.

Memo

0.00

4 0

Jm / 12-4-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Small Fab

Memo

0.00

Small Fab

Deburr if necessary

140

0.00

140

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform using mold DT9489 as per dwg

x4

Jh
12/05/15

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Item Name: Panel, Side

Stop ***NS2***

Start Date: 4/12/2012 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 4/26/2012 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

170

0.00

170

Small Fab

Memo

0.00

Small Fab

1- Bond gasket to smooth side of panel as per dwg
A/R 3M 1300 adhesive Batch: 120904

Drills

(M)

4

0

FF 12-06-27

4

0

FF 12-06-27

W/O:		WORK ORDER CHANGES					
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Stop

NS2

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

5/17/06/27

(44)

190

Identify as per dwg & Stock Location:

0.00

190

Packaging

Memo

0.00

Packaging

PPP
86377

4/4/27 (4)

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

12/6/27

MF

12-06-27

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, April 12, 2012 10:25:56 AM

Page 1

Work Order ID: 82995
Parent Item: D3890-041
Parent Item Name: Panel, Side

Start Date: 4/12/2012 Required Date: 4/26/2012
Start Qty: 4.00 Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SHEET		Purchased	No			100	sf	688.7974	3.618	15.233684			

				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
				MAT019	688.7974	
				119937	688.7974	
D3890-3 Gasket		Manufactured	No		160	Each 6.0000

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST242 83934	6	
	81018	6	

119937

2 8

2
6

JM/WW
12-4-30
(4) EF 12-06-27

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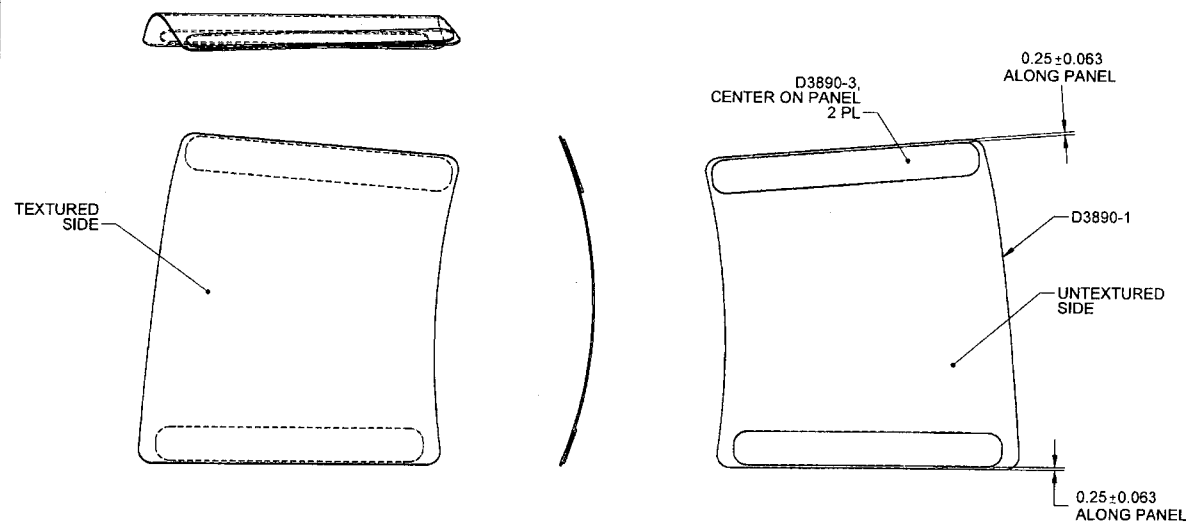
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3890-041	PANEL, SIDE
2	1	D3890-1	PANEL
3	2	D3890-3	GASKET
5	A/R	3M 1300	ADHESIVE



D3890-041 PANEL, SIDE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3890-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.48 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE.

A	NEW ISSUE	CP	09.05.01
REV.		BY	DATE
DESIGN	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	GP		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3890	SHEET 1 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	PANEL, SIDE	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
09/05/01

82495

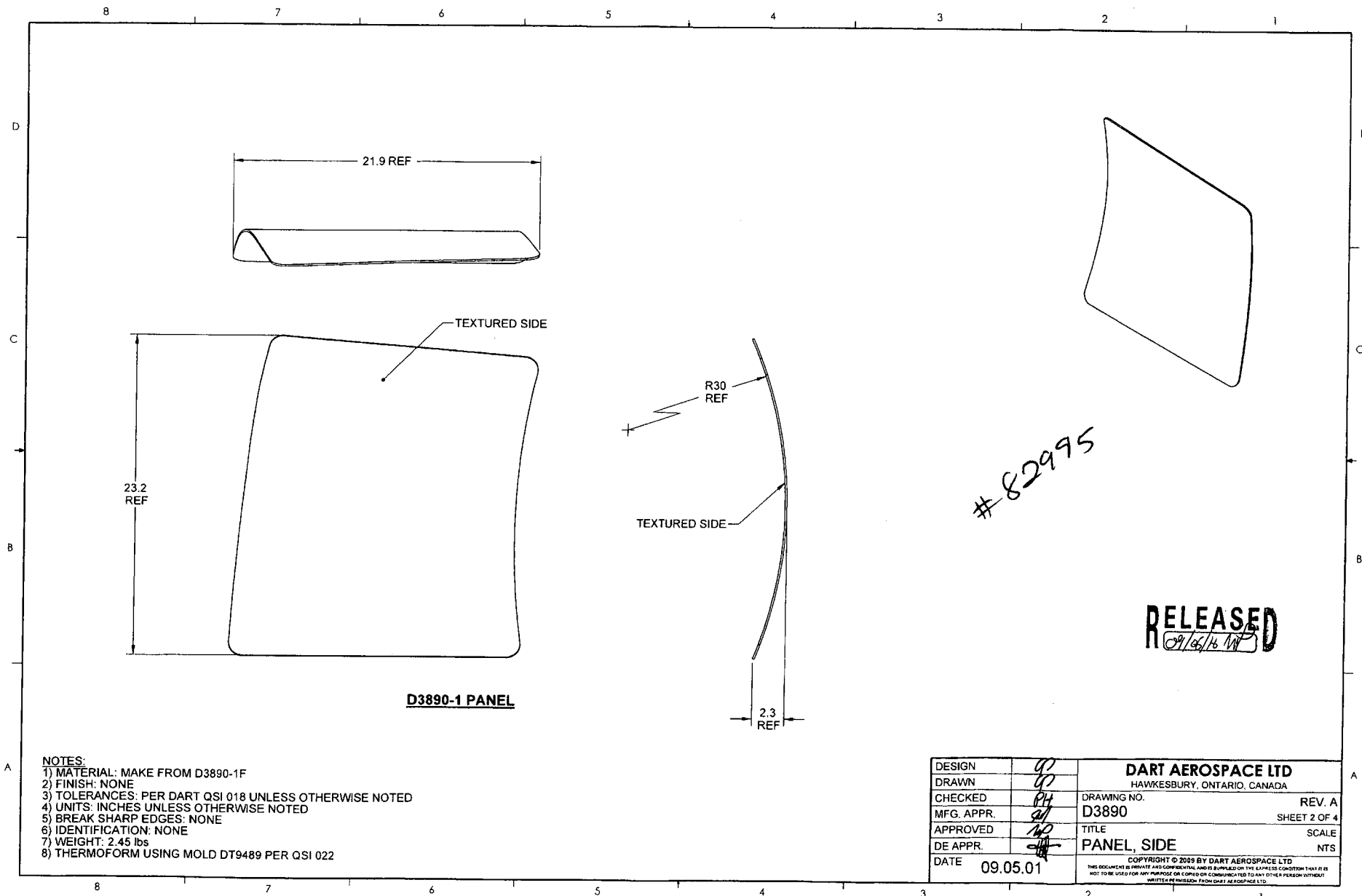
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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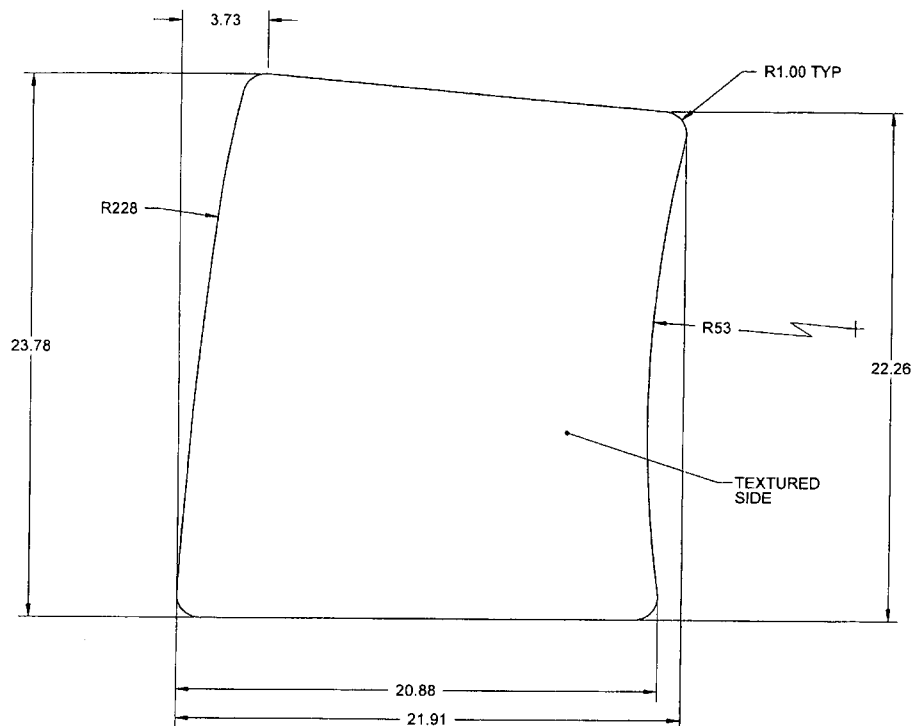
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NOTE: Date & initial all entries



D3890-1F PANEL

RELEASED
9/06/16

NOTES:

- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.45 lbs

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	27	D3890	SHEET 3 OF 4
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DE APPR.	27	PANEL, SIDE	NTS
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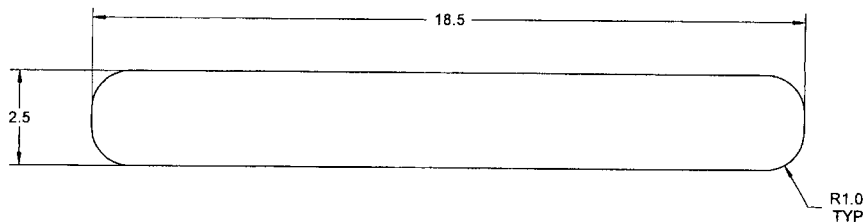
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

0.125
REF



D3890-3 GASKET

#82995

RELEASED
2/10/16 MJD

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	94	DRAWING NO.	REV. A
MFG. APPR.	94	D3890	SHEET 4 OF 4
APPROVED	94	TITLE	SCALE
DE APPR.	94	PANEL, SIDE	NTS
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8 7 6 5 4 3 2 1

A

A

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